Worl	Or	der	ID	6600	14
***	\ \ /	u	11/	*****	,-



Page 1

Item ID:

D3391-021

Accept



Setup Start

Stop

Stop



Revision ID:

Item Name:

Fwd Tube Assembly

Start Date:

2/2/2011

Tuesday, February 01, 2011 12:58:04 PM

Start Qty: 1.00

Required Date: 2/7/2011

Req'd Oty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date: Tooling:

Revision Nbr

Operation

Description

Date:

Date:

Start Run

QC: _____

Date: _____ SPC (Y/N):

Set Up/

0.00

0.00

0.00

Run Hours

Tool ID

Tool # Plan Code

Accept Qty Qty

Reject Reject

Insp. Number Stamp

Work Center ID Draw Nbr

Sequence ID/

D3391

Rev H

100

Skidtubes

Skidtubes

Skidtubes

Memo

Cut extrusion to 46.52 +0.010 -0.020

110

CNC Bend I

BENDING MACHINE - SKIDTUBES

Memo

0.00

CNC Delta 100 Bender

Bend as per Dwg D3391 Using Bend Prog 3391021

120.

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

W/O:		WORK ORDER CH	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _			

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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Tuesday, February 01, 2011 12:58:04 PM



Page 2

Insp.

Stamp

D3391-021 Item ID: Accept Setup Start **Revision ID:** Stop Fwd Tube Assembly **Item Name: Start Date:** Start Qty: 1.00 2/2/2011 **Cust Item ID:** Required Date: 2/7/2011 Req'd Qty: 1.00 **Customer:** Reference: Start Run Process Plan: Date: Tooling: Approvals: Date: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Accept Reject **Work Center ID** Description Qty Qty Code Number **Run Hours** 130 0.00 HAAS CNC VERTICAL MACHINING #1 HAAS 1 0.00 1-Machine as per Folio FA590 Rev. A & Dwg D3391 Rev. \ HAAS CNC vertical machine #1 Identify as D3391-1 2-Deburr 140 QC2- Inspect parts off machine FAI/FAIB 0.00 0.00 Memo Quality Control

0.00

150

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

0.00 Memo Drill.X1 Aft cap as per Dwg D3391 .1875" dia

Dart Aerospac	ce Ltd
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W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:		.,	WORK ORD	ER NON-CONFORMA	ANCE (NCF	R)			
	STEP Description of NC Section A	Description of NC	Corrective Action Section			Verifi	cation	Approval	Approvai
DATE		Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		tion C	Chief Eng	QC Inspector	
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Tuesday, February 01, 2011 12:58:04 PM



Page 3

Item ID:

D3391-021

Accept

Setup Start

Stop



Revision ID:

Item Name:

Fwd Tube Assembly

Start Date:

2/2/2011

Start Oty: 1.00

Req'd Oty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Run

Stop

Start

Required Date: 2/7/2011

QC:

Date:

SPC (Y/N):

Date:

Date:

Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/ Run Hours

0.00 SL 11/02/16

0.00

Tool ID

Tool # Plan Code

Reject Accept Qty Qty

Reject Number

Insp. Stamp

170

Quality Control

OC8- Inspect parts - second check

Memo

Memo

0.00

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1 1

Dart Aerospace	Ltd	
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W/O:			W	ORK ORDER CHANGI	ES					
DATE	STEP	PROCEDURE CHANGE				,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Tuesday, February 01, 2011 12:58:04 PM

Item	ID:

D3391-021

Accept

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 2/7/2011

Fwd Tube Assembly

Start Date:

2/2/2011

Start Qty: 1.00

Reg'd Oty: 1.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Reject

Qty

Stop



Sequence ID/

Work Center ID

180



Skidtubes

Skidtubes

 Operation **Description**

QC: ____

Set Up/

Run Hours

Tool # Plan

Code

Accept Qty

Reject Number

Insp. Stamp

Skidtubes

Memo

0.00

0.00

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)

(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr & Scribe Batch number Inside aft end.

drill_D3391-021_with D3391-023 _k) /

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Dart Aerospace	£Ltd
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W/O:			W	ORK ORDER CHAI	NGES					
DATE	STEP	P	ROCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Tuesday, February 01, 2011 12:58:04 PM

2/2/2011

QC:



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Item ID:

D3391-021

Accept

Setup Start



Revision ID:

Start Date:

Item Name:

Required Date: 2/7/2011

Fwd Tube Assembly

Start Qty: 1.00

Req'd Qty: 1.00



Date:

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop



Sequence ID/

Work Center ID

200

HandFinish

Operation Description

Chemical Conversion Coat per OSI005 4.1

Set Up/ **Run Hours**

0.00

0.00

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Hand Finishing

210

QC

Quality Control

QC3- Inspect Part Finish

Memo

Memo

Memo

0.00

0.00

0.00

0.00

220

Skidtubes

Skidtubes

Skidtubes

1-instal spacers as per dwg D3391

A/R Magnabond 6398 batch: 11/02/27

exp. date: 05/201/

cure time 12hrs. as per QSI015

2- grind crossbolt flush

3-back drill crossbolt if necessary

| BE 11/02/24

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES							
DATE	STEP	PRO	DCEDURE CHAN	CEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Page 6

Item ID:

D3391-021

Accept

Setup Start

Stop



Revision ID:

Item Name:

Fwd Tube Assembly

Start Date:

Required Date: 2/7/2011

2/2/2011

Start Otv: 1.00

Rea'd Otv: 1.00

Date:

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling: SPC (Y/N): Date:

Run

Stop



Sequence ID/

Work Center ID

Ouality Control

Operation Description

QC:

OC5- Inspect part completeness to step on W/O

Set Up/ Run Hours

0.00

0.00

Date:

Tool # Plan Code

Accept Otv

Reject Qty

Reject Number

Insp. Stamp

235

HandFinish

Hand Finishing

Pressure Wash per OSI005 4.3

Memo

0.00

a 00.0

AND REALODINE AS PER PAR09-043

1 6 91 1102/21

240

Powdercoat

Powder Coating

White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

Memo

0.00

1 BL 11-2.25

0.00

Dart	Aerospace	Ltd
		

Dart Ae	rospace l	Ltd							<u> </u>
W/O:			WO	RK ORDER CHANGE	S				
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NCR:			WORK ORDE	R NON-CONFORMAN	ICE (NCR)			
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		tion C	Chief Eng	QC Inspector
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Work	Order	ID	66	004
Tuesday.	February	01.	2011	12.5

Quality Control



Page 7

Tuesday, Febru	ary 01, 2011	12:58:04 PM										1 ugc 7
Item ID: Revision ID:	D3391-021			Accept					Setup		1 13211111 1	
Item Name:	Fwd Tube A	ssembly								Stop		
Start Date: Required Date	2/2/2011 : 2/7/2011	Start Qty: 1.00 Req'd Qty: 1.00			Cust Item I Customer:	D:						
Reference:											1 182:118: 8	
Approvals:	Process P	lan:	Date:	Tooling:	Da	ate:			Run	Start		
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop		
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
250 QC		QC3- Inspect Part Finish		0.00					4	/	11/0	2/28 N
Quality Control		Memo		0.00					,			
255		Skidtubes		0.00				i		K	ا له	1/02/20
Skidtubes		Memo		0.00						φ	14	110420
Skidtubes		DWG ****	03591-1 spacer as per D	SI9364 and wearplate and	d gasket as per		-					
257		QC5- Inspect part comple	teness to step on W/O	0.00	S w/28			(A)				
QC		Memo		0.00	5 000-100			(20				

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STEP	PRO	OCEDURE CHAN	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Tuesday, February 01, 2011 12:58:04 PM



Page 8

Item ID:

D3391-021

Accept

Setup Start



Revision ID:

Item Name:

Fwd Tube Assembly

Stop

Start Date:

Start Oty: 1.00 2/2/2011 Required Date: 2/7/2011

Req'd Oty: 1.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: Date:

Operation

Description

Tooling:

Date:

Run

Start

OC:

Date: **SPC (Y/N):** Date:

Stop



Sequence ID/ Work Center ID

260

Packaging

Memo

0.00

0.00

Set Up/

Run Hours

Tool ID

Tool # Plan Code

Accept Qty

Reject Otv

Reject Number Stamp

Insp.

Packaging

280

OC

Quality Control

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location:

0.00

Memo

0.00

-11/02/28 A) MF 11-02-28

Dart Aerospace Ltd

Duit Aci	ospace	LIM							
W/O:			W	ORK ORDER CHANG	GES				
DATE	STEP	P,R	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	_ Date: _	
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NCR:			WORK ORI	DER NON-CONFORM	ANCE (NCR	1)			
DATE	STEP	Description of NC		Corrective Action Sec			Approval	al Approval	
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Tuesday, February 01, 2011 12:58:01 PM

Work Order ID: 66004

Parent Item:

D3391-021

Parent Item Name: Fwd Tube Assembly



Start Date: 2/2/2011

Start Otv: 1.00

Required Date: 2/7/2011

Required Oty: 1.00

Comments:

IPP A□05.09.13□New issue□

KJ/JLM□ IPP B□06.02.10□Dwg rev.D ecn 773 □EC□

IPP C□06.05.02□Added inspections

IPP D 07.03.13 rev F dwg

EC

No

No

IPP E 07.11.07 revG dwg ecn1053P

EC verified by: DD

IPP Rev:f ECN 1056 07-11-12 DD verified by: EC

IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC

IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC

Manufactured

Manufactured

IPP Rev J 09.02.02 added hardware EC verifified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6013-047		Manufactured	No			100	Each	34.0000	1	1			
		•											

Skidtube Material

Location	Lo	c Oty	Loc Code
LG		34	
23935		3	
26547		31	
	220	Each	56.0000

SPACER

D3401-041

D3670-4-200

Location	<u>Lo</u>	c Oty	Loc Code
LG		56	
57349		34	
63317		22	
	255	Each	11.0000

Tow Cap Assembly

Location	Loc Qty	Loc Code
FP	11	
46029	10	
50316	1 .	

Dart Ae	ospace	Ltd
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W/O:			WC	RK ORDER CHANGE	S				,	
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _		
	Re	esolution:	Dispositio	n:	QA: N/C C	osed:		Date:		
NCR:		,	WORK ORD	ER NON-CONFORMA	NCE (NCF	₹)				
DATE	CTED	Description of NC						Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		tion C	Chief Eng	QC Inspector	
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Tuesday, February 01, 2011 12:58:01 PM

Work Order ID: 66004								
Parent Item: D3391-021								
Parent Item Name: Fwd Tube Assembly	ý			•••		Start Date: Start Qty:		Required Date: 2/7/2011 Required Qty: 1.00
03564-13 Wearshoe	Manufactured	No		255	Each	13.0000 1	1 11	loz 15
			Location FP17 59660 62229	<u>Loc</u>	13 1 12	Loc Code		- -
03566-13 Gasket	Manufactured	No		255	Each	23.0000 1	1 Hl	11/02/20
			Location FP012 61996 FP014	<u>Lo</u>	3 3 20	Loc Code		- -
AN960C10L NAS1149C0332 R washer	Purchased	No	64070	255	20 Each	25.0000 10	10 Il u	102/28
AN3C4A	Purchased	No	Location ST245 107534	<u>Lo</u> 255	25 25 Each	Loc Code AA 6304 2,072.000 10		- - - 1102/78
30L1	,	,	Location ST350 115300 116075 116590 116704	<u>Lo</u>	2072 25 947 100 1000	Loc Code		

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC			ction B	Cimm 0		cation	Approval	Approval
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Picklist Print

Tuesday, February 01, 2011 12:58:02 PM

Page 3

Work Order ID: 66004

Parent Item:

D3391-021

Parent Item Name: Fwd Tube Assembly



Start Date: 2/2/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Phenolic Washer

Manufactured

No

255

Each

1,307.000

M 1102/28

<u>Location</u>	<u>l</u>	<u>L</u>	oc Oty	Loc Code		
ST077			1307			·
	42329		10			
	52505		297			<u> </u>
	64177		1000			
		255	Each	0.0000	2	2
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		255	Each	0.0000 768	10 	10

AELS-1032-130 INSERT

AELS-1032-225

Purchased

Purchased

No

No

X10 12 110-128

INSERT

Dart Aerospace Ltd

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W/O:			W	ORK ORDER CHAN	GES	===			,
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DART AEROSPACE LTD	Work Order:	66004
Description: Float Skidtube (412)	Part Number:	D3391-1
Inspection Dwg: D3391 Rev: H		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

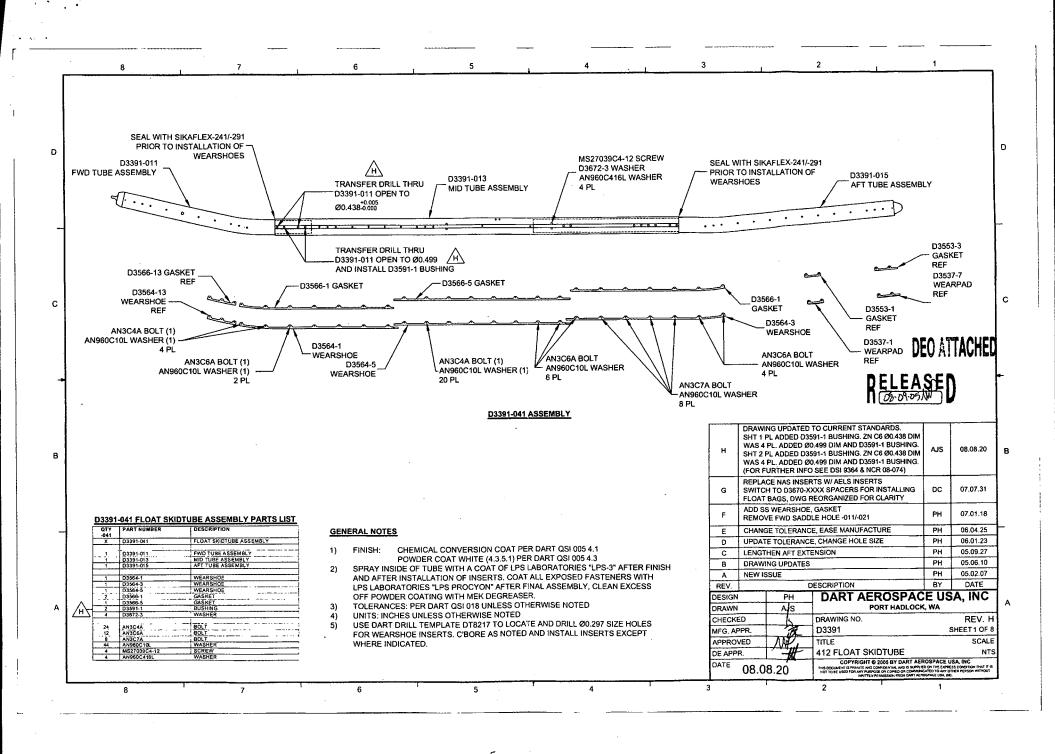
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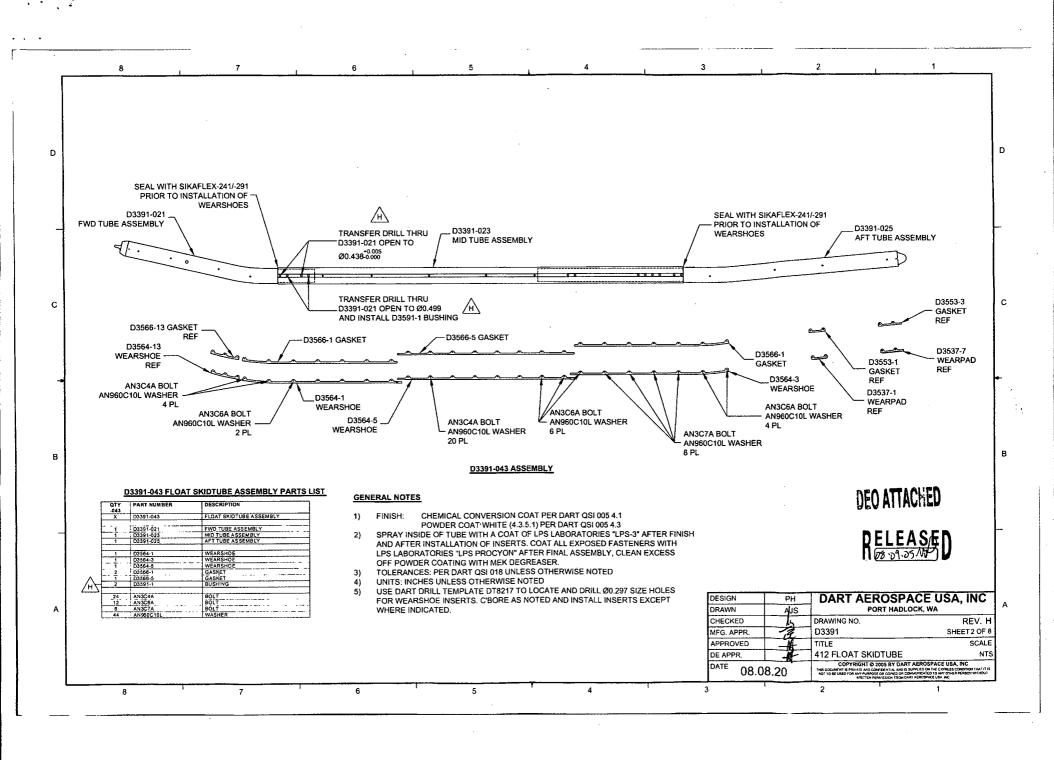
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+0.010/-0.000	-693			Vern JL-3	
3.590	+0.025/-0.010	3.6/5	/		mic JLM-Y	
3.300	+0.040/-0.000	3 340	/			
1.429	+0.040/-0.060	1.421				
4.250	+/-0.010	4.248	1			
4.250	+/-0.010	4.24	/			
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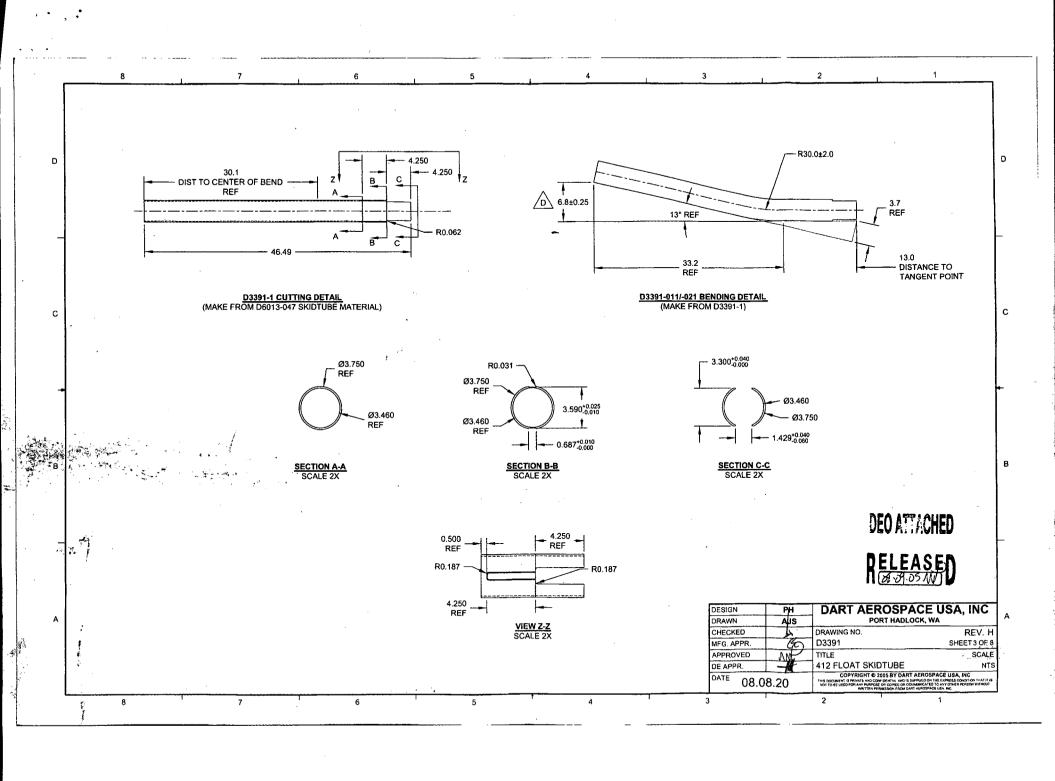
Measured by:	Audited by:	Duf	Prototype Approval:	N/A
Date: 11/62/15	Date:	11/02/12	Date:	N/A

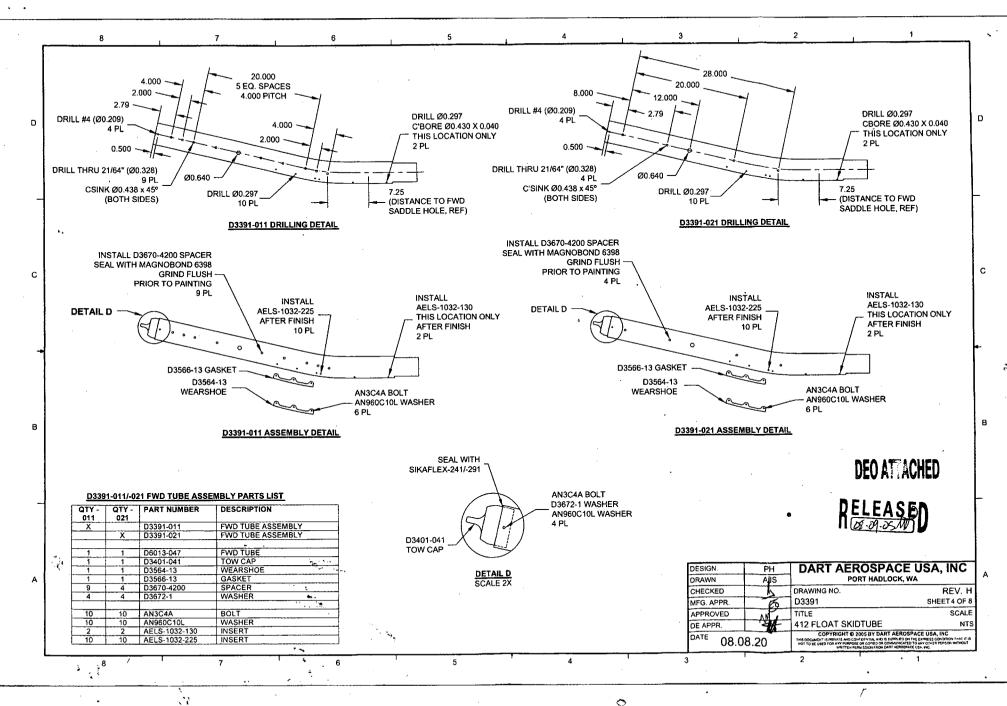
Rev	Date	Change	Revised by	Approved
Α	06.04.27	New Issue P/O D3391-011/-021	KJ/JLM	Ţ
В	06.06.19	Tolerances revised per D3391 Rev. E	KJ/JLM	
С	07.03.21	Dimensions removed per Dwg rev. F	KJ/JLM	
D	07.11.23	Dwg Rev. updated	KJ/EC/DD	
E	09.12.14	Dwg Rev updated	KJ \$\$	

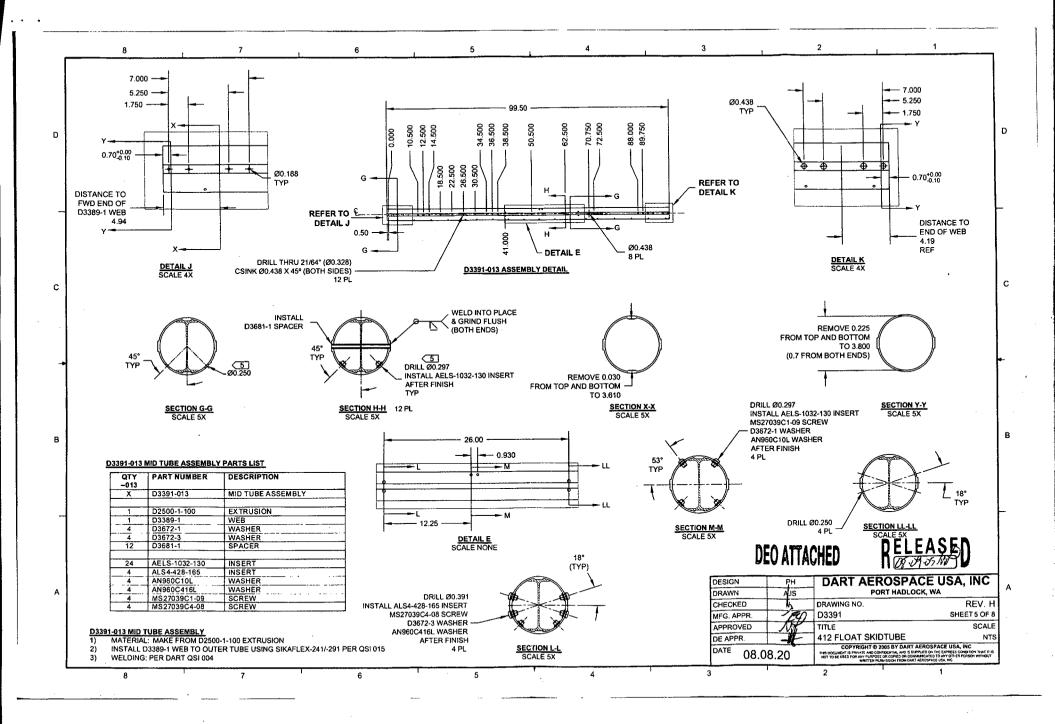


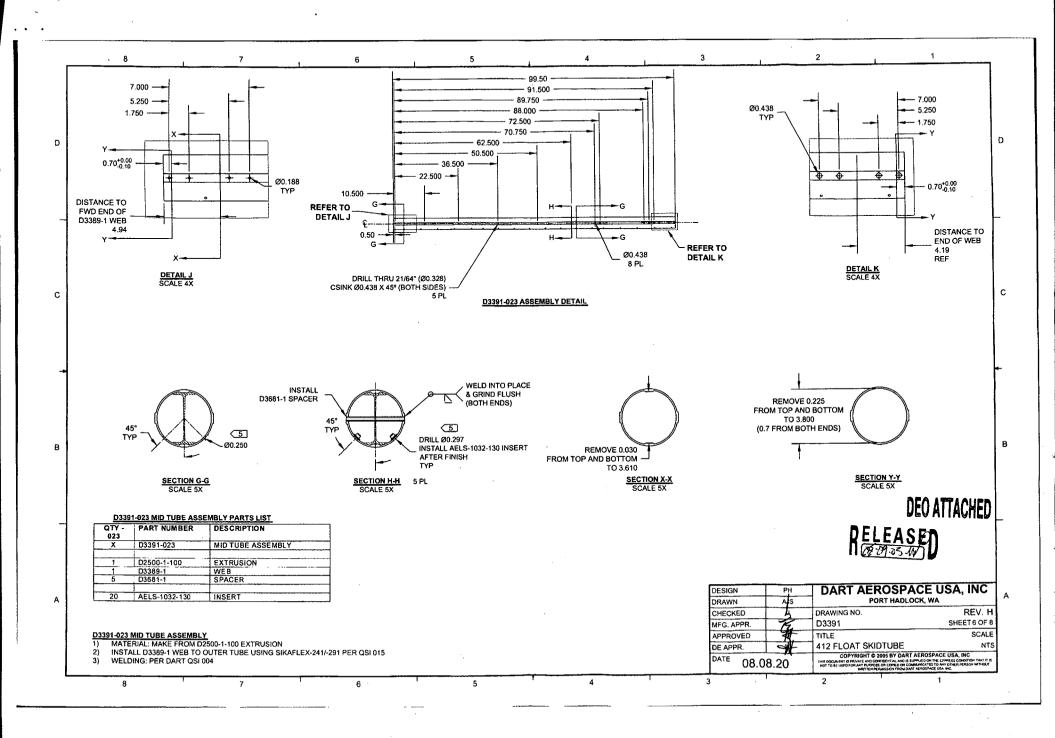


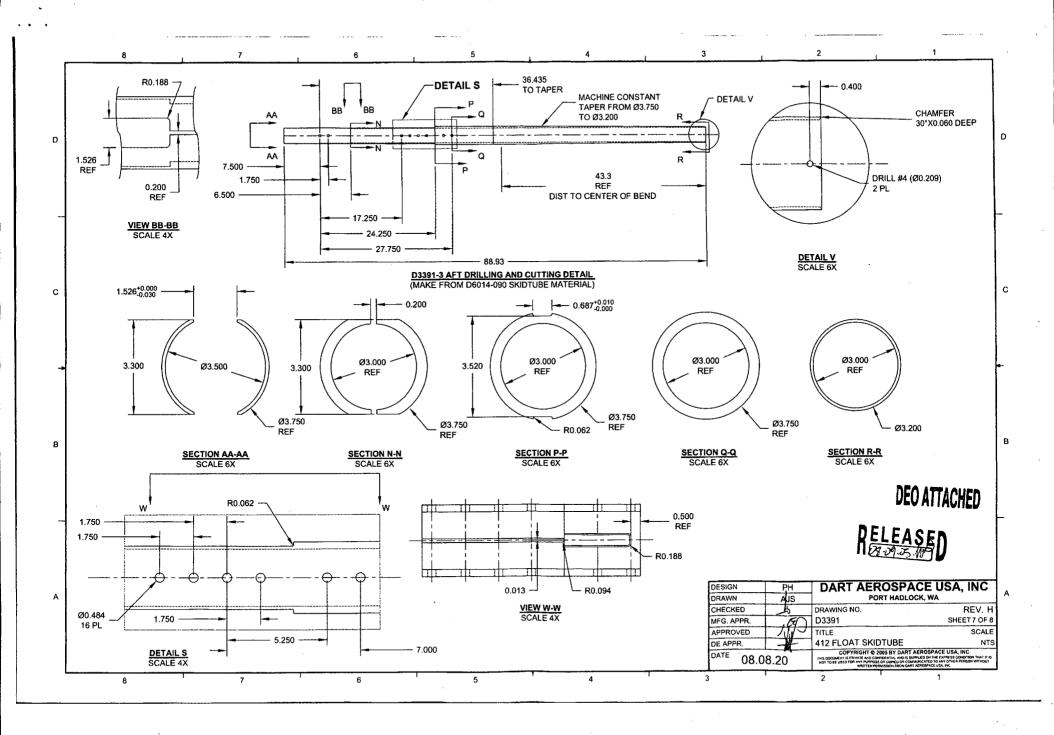


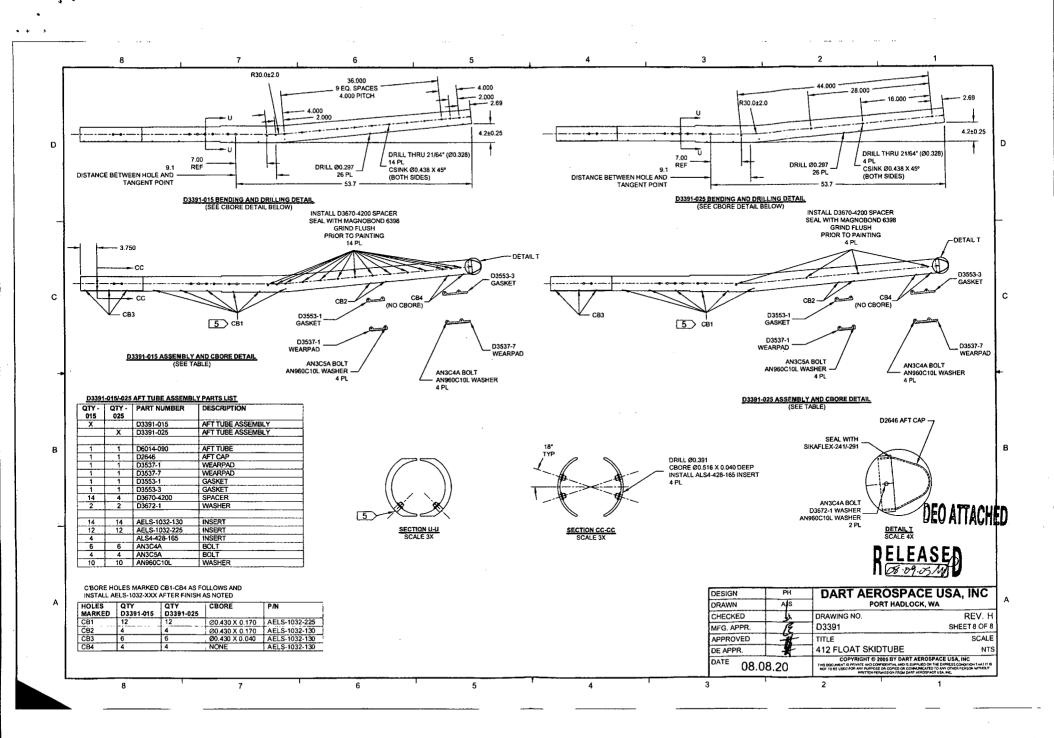












DRAWING	NO. TI	TLE	REV. H	ART AEROSPAC	E USA, INC D.E.O. NO.	SHEET NO.	SCALE
D3391	4	12 FLOAT SKIDTUBE	.]	ENGINEERING	ORDER D3391-H-1	SHEET 1 OF,1	NTS
DRAWN	(P	CHECKED	ļ,	MFG. APPR.	APPROVED NW	DE APPR.	
DATE	09.09.23	DATE	04.04.24	DATE 09/09/	25 DATE 09/09/30	DATE 09/09/3	0

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

2) SPRAY INSIDE OF TUBE WITH A GOAT OF LPS LABORATORIES "LPS-3" AFTER FINISH-AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

DELEASED 2010 -02- 0 2

MP

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